

Work Order ID 57487

April 7, 2010 11:10:56 AM



Page 1

Item ID: D3267-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly (Inside)

Start Date: 4/07/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

100

Weld per dwg A/R S.S. rod Batch: 4113328 0.00
Large Fab



Large Fab

Large Fab

Memo

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-043 as per Dwg D3267

4-Deburr & Remove All Markings From Material

SAD 10-04-09

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

1 SY 10/04/21 (1)

Work Order ID 57487

April 7, 2010 11:11:00 AM



Page 3

Item ID:	D3267-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly (Inside)				Stop	
Start Date:	4/07/10	Start Qty:	1.00			
Required Date:	4/16/10	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	1ST START TIME: 8:00AM OVEN TEMPERATURE: 400°F FINISH TIME: 8:30AM ***** 2nd coat if necessary*****								
	2ND COAT: START TIME: 8:45AM OVEN TEMPERATURE: 400°F FINISH TIME: 9:15AM								
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

1114207

=> 10/04/26

1 0

Pb =>

Subtotal 22

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3267-043 PAR #: N/A Fault Category: Finishing NCR: Yes No DQA: NA Date: 10/05/03
Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: 10/05/03

NCR: <u>57487</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/27	#130	Marking came through the Powder coat in one area all around the mesh. R.C. mesh wasn't cleaned enough	<u>JB</u> 05/21/27	- Scuff off p/c to remove red marking - Scuff rest of lid to have p/c Match.	<u>JB</u> 10/01/27	<u>S</u> 10/01/27	<u>JB</u> 05/21/27	<u>S</u> 10/01/27
			<u>JB</u> 05/21/27	- clean lid with acetone to remove marking. M114207 - Re p/c per 052005	<u>JB</u> 10/01/27	<u>S</u> 10/01/27	<u>JB</u> 05/21/27	<u>S</u> 10/01/27
				START: 9:00AM Temp: 400°F FIN 9:30AM M114207	<u>JB</u> 10/01/27 X1			

NOTE: Date & initial all entries

Picklist Print

April 7, 2010 11:10:55 AM

Page 1

Work Order ID: 57487

Parent Item: D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Comments: IPP Rev:C Removed -041 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
 by:EC
 IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Start Date: 4/07/10

Required Date: 4/16/10

Start Qty: 1.00

Required Qty: 1.00

D3166-3

Manufactured No

100

Each

9.0000

0.0000



Basket Hoop

NA W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

9

55697

3

56426

6

Manufactured No

100

Each

0.0000

2.0000

D3182-1



Hinge

D3442-3



Shim

B 57602 (2) 10/04/16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

22

53137

4

56204

18

(2x) 10/04/16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 7, 2010 11:10:55 AM

Page 2

Work Order ID: 57487

Parent Item: D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Comments: IPP Rev:C Removed -041 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecm 08-524) DD verified
 by:EC
 IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Start Date: 4/07/10

Required Date: 4/16/10

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

530.2458 7.3684



304 SQ Tube .75x.75x.065W



SAD 10-09-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

530.2458

111148

58

113956

23.5

114137

448.7458

7.3684

M304EX0.75-16F

Purchased

No

110

sf

656.3474 4.5263



Expanded Metal Flat SS



SAD 10-09-09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

656.3474

111956

28

112949

12

113497

28

113555

303.45

113904

43.2132

114212

241.6842

4.5263

April 7, 2010 11:10:55 AM

Shop Packet Print

Page 2

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

also 57487

RELEASED
08-09-14

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3267	SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8

7

6

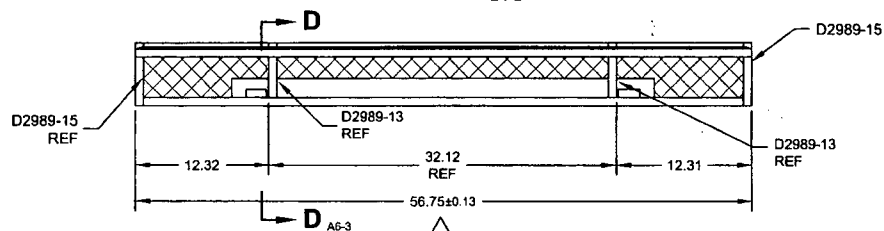
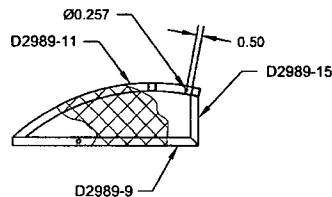
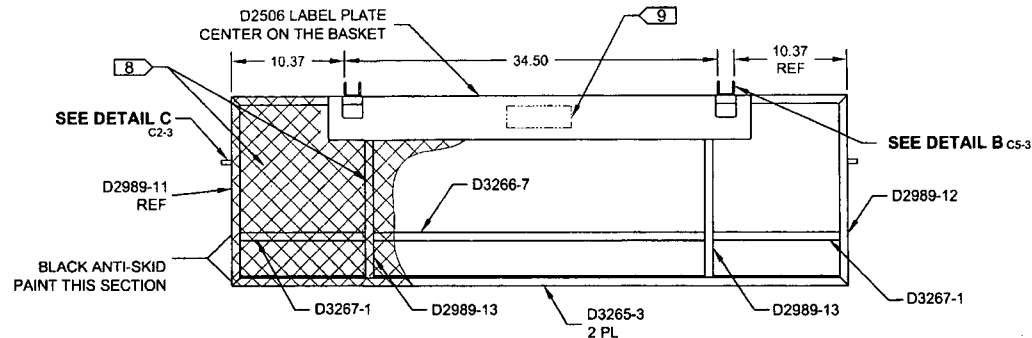
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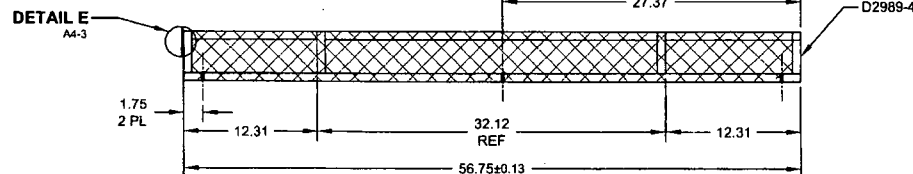
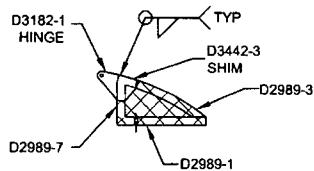
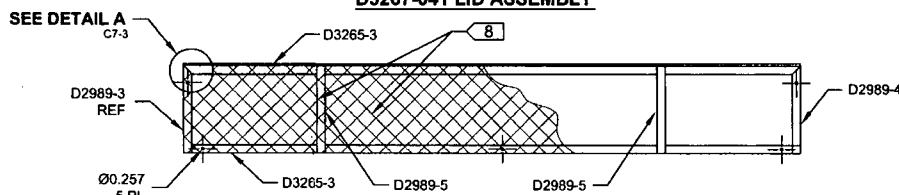
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2

1



D3267-041 LID ASSEMBLY



D3267-041 LID ASSEMBLY



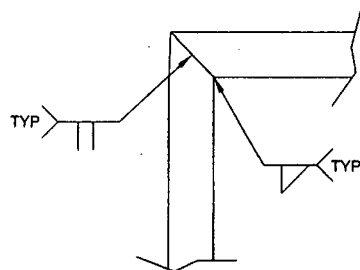
NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

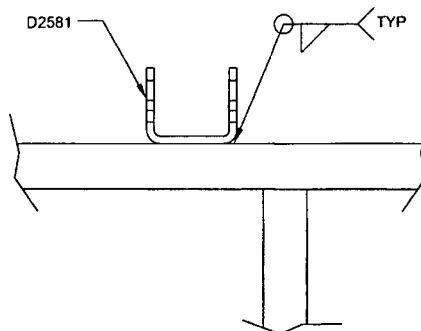
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08.07.04/17

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MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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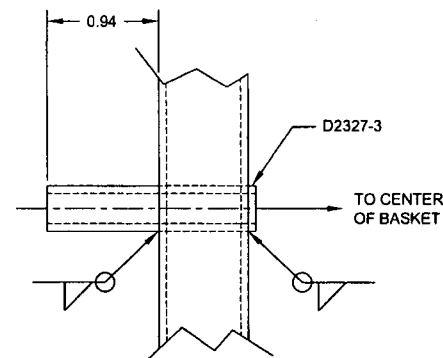
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DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X

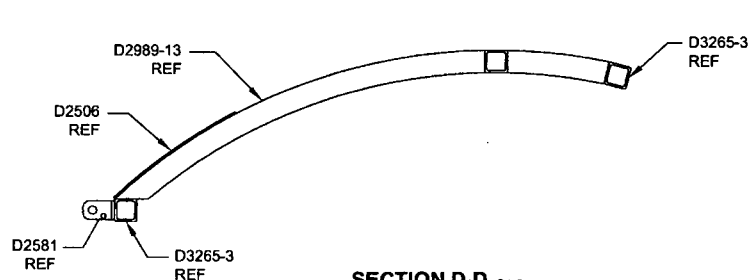


DETAIL B D2-2
2 PL
SCALE 2X

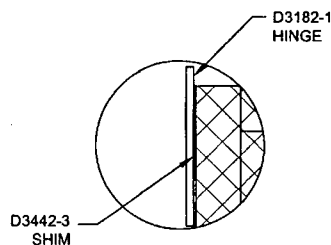


DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X

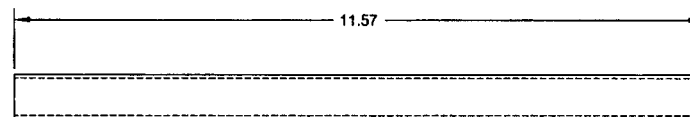
W. J. 10/87



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL

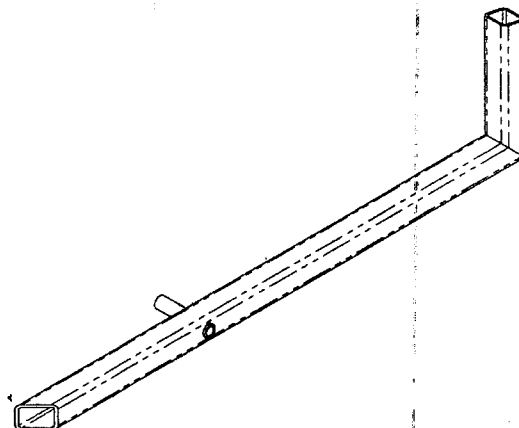


D3267-1 STRUT
SCALE 2X

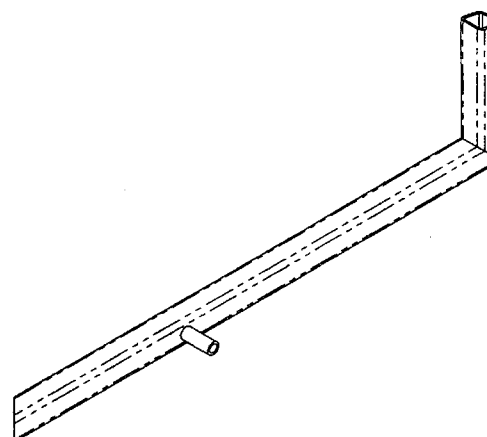
RELEASED
08-07-09/10

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSMEBLY	NTS
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8 7 6 5 4 3 2 1



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

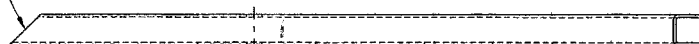
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1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

RELEASED
08/11/18 MP

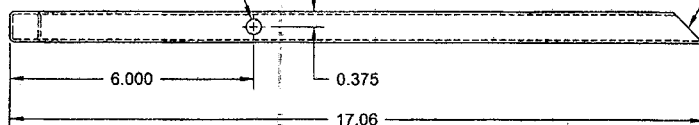
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DESIGN		DESCRIPTION	BY DATE
DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

0.75 X 45°
CHAMFER

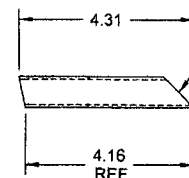


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



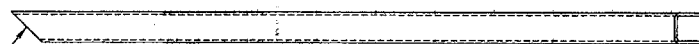
D3836-1 RIB



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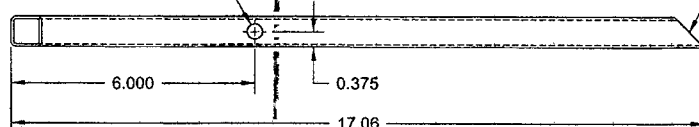
D3836-3 RIB

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CHAMFER

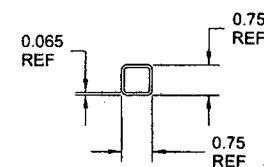


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



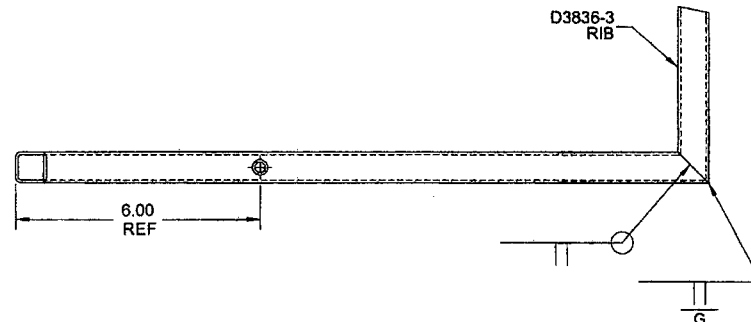
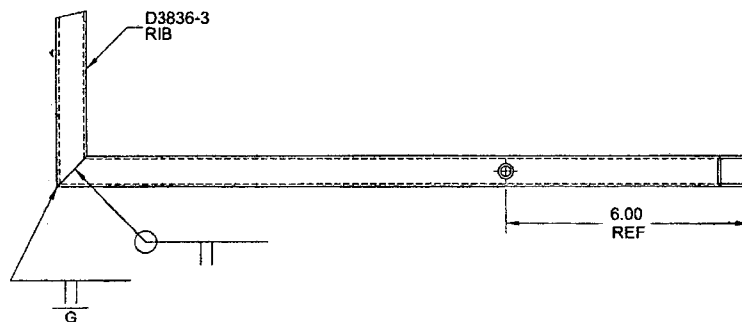
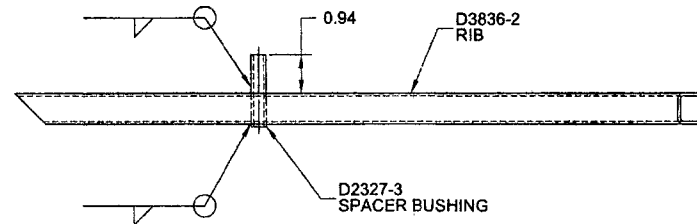
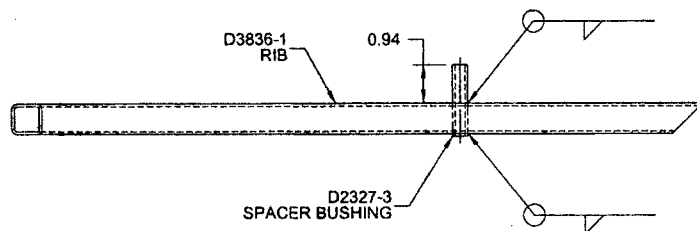
**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.		TITLE RIB ASSY (BASKET LID)	SHEET 3 OF 3
APPROVED			SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

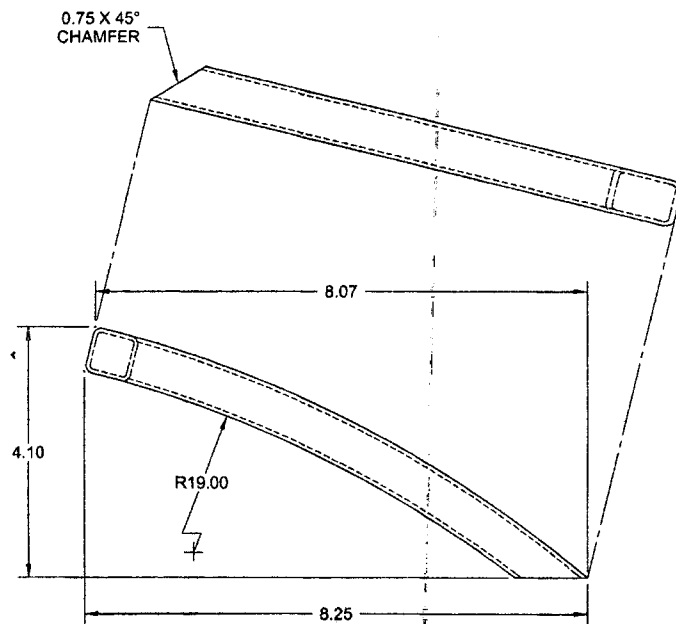


D3836-041 RIB ASSY (BASKET LID, LH)

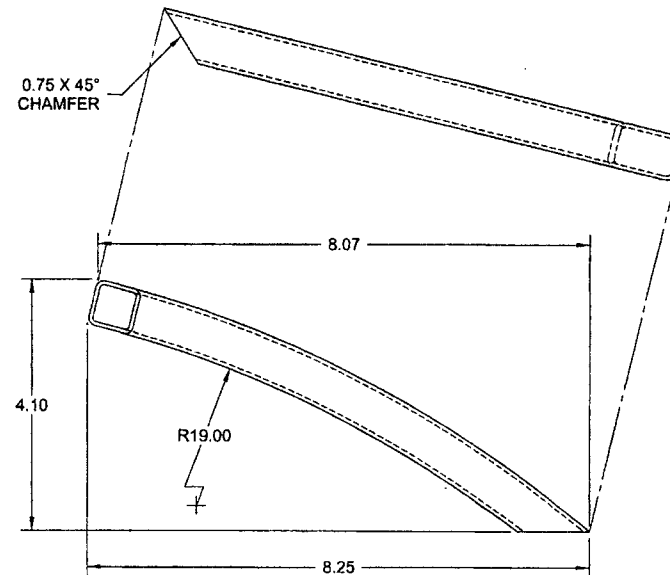
D3836-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/18 NTP

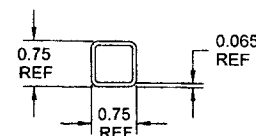
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3836	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2989-3 RIB



D2989-4 RIB

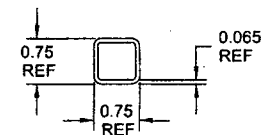
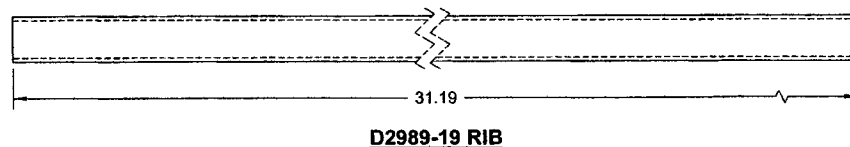
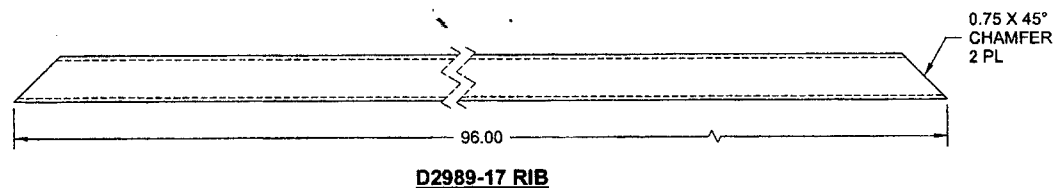
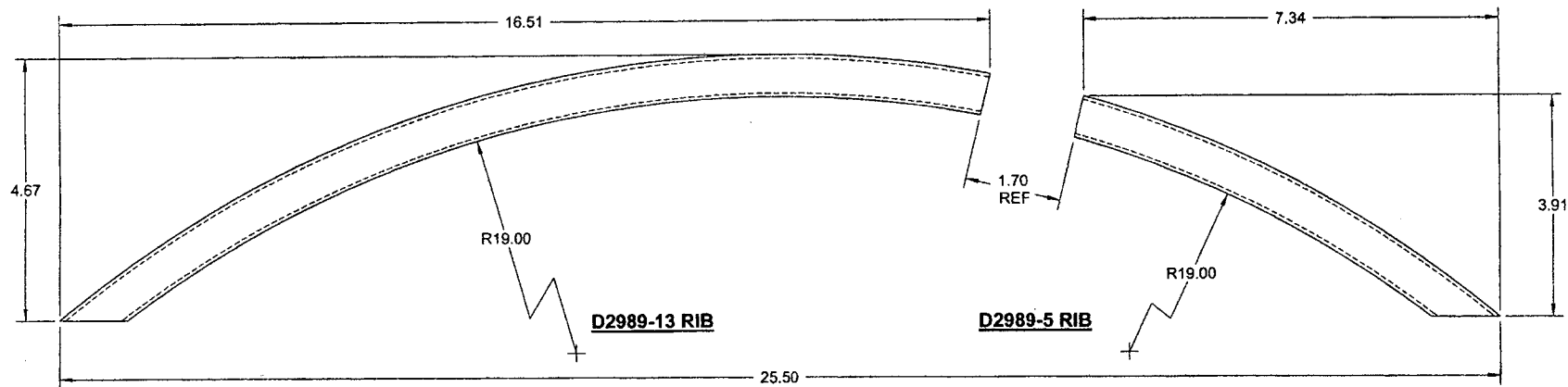


**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



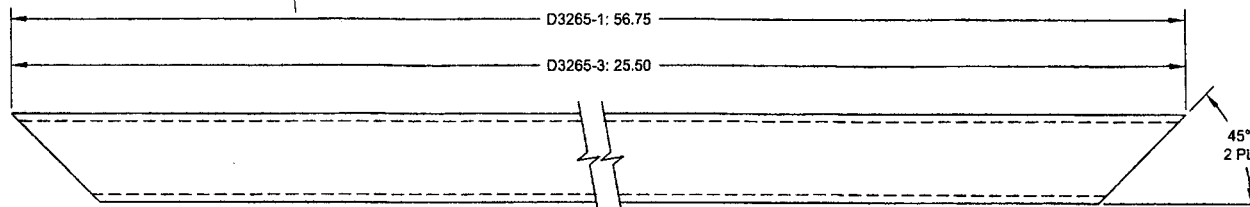
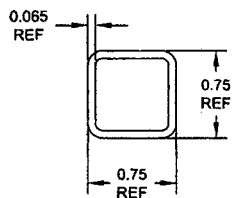
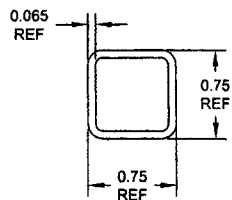
TYPICAL SECTION
VIEW

RELEASED
08/11/78

NOTES:

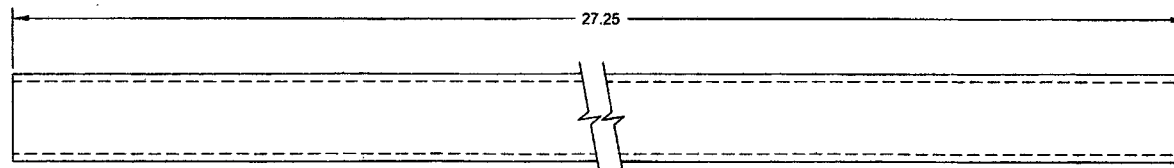
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D2989	REV. D
MFG. APPR.	N/A	SHEET 5 OF 5	
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BASKET LID ASSEMBLY	NTS
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D3265-1 RIB

D3265-3 RIB



D3265-5 RIB

**DEO ATTACHED
RELEASED**
08.09.14

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3265	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	